

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007861**Date Inspected:** 24-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

OBG External Segment Repair Yards and Bays 13-14.

This QA inspector reviewed the request for information #RFI-ZPM-000635R00 that was submitted by ZPMC on 31 March, 2009 requesting a change of joint design when the following condition arises; when a gap between fillet weld seams that exceeds 5mm a CJP weld is adopted instead of the required fillet weld. ZPMC requested that the UT inspection requirement for CJP welds be waived and an MT inspection be performed in lieu of required UT inspection. The Box Girder Segments as listed below were visually inspected and locations were verified that contain a CJP weld in lieu of a fillet weld. This was a random QA verification and does not list all welds with the above condition. See incident Report on this date.

OBG Segments inspected for the above mentioned are as follows; 6AW, 6BW, 6AE, 6BE, 7AE, 7BE, 7CE, and 7EE.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
